

Split - 2

Work Order ID 86348 - 2

86348

Page 1

June-27-12 3:20:59 PM

Item ID: D2274

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Radius Block

Start Date: 27/06/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 12/10/28 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00

100

SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 86348

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Item ID: D2274

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Radius Block

Start Date: 27/06/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Jul 12-07-20 136

140

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

TumbleDeburr any rough edges after tumbling

136 -SAD 12-7-20 136

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

136 SAD 12-07-20

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Page 3

Item ID: D2274

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Radius Block

Start Date: 27/06/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo
12.07.20

0.00

DAS
16 12/07/20

136

170

Identify as per dwg & Stock Location: 25009

0.00

170

Packaging

Memo

0.00

Packaging

136

12/07/2020 B

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/17/2020

UMF
12-07-23

Picklist Print

June-27-12 3:21:03 PM

Page 1

Work Order ID: 86348

86348

Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H100.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased		No		100	f	114.5030	0.0916	19.28421			

M6061T6B00750X00 125

**

6061-T6 Bar .750 x .125

Location	Loc Qty	Loc Code
MAT001	111.168	
116406	2.75	
117653	8.418	
→ 122081	100	
MAT003	3.335	
120603	3.335	

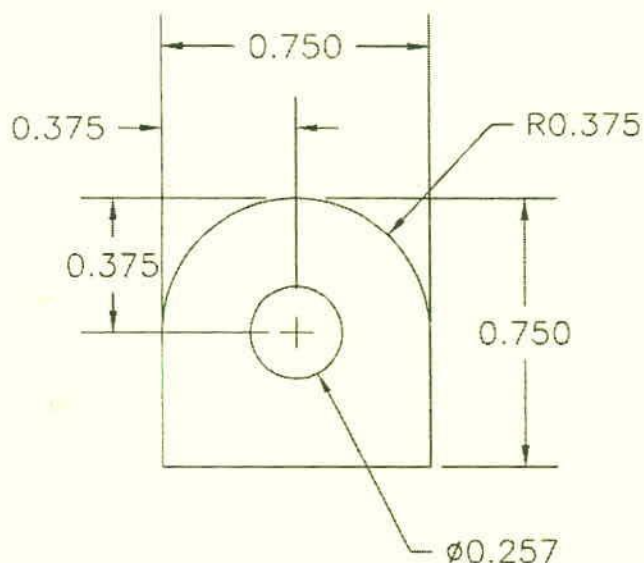
20

OK 12/07/16

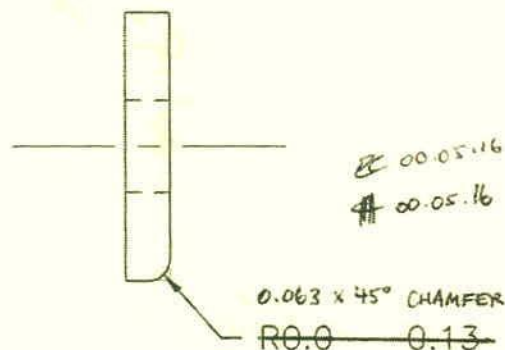


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MP</i>	APPROVED <i>AS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/19 KE



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86342 HCS
12/06/28



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

